

Work Order ID 119938

119938

Page 1

May-30-14 8:41:50 AM

Item ID: D350-636-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Stop *NS2*

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-05-30 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4168-043	B
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100	Document Control	0.00
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100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D350-636-017 CHG 005

N/A MLS 14-06-10

89.9°
FWD
3C 14-06-04

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Item ID: D350-636-017

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N900040100

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Start Date: 5/30/14 Start Qty: 1.00 *1*

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616 detail S. Ensure proper positioning.

6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

7-Open up holes of Detail S to 0.297" (total of 2 holes per side) +.201"(total of 1 per side)

8-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

> 14-6-2014/85

DC 14/06/04

DQA: Ant Date: 14/06/24QA Closed: Ant Date: 14/6/10

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>119938</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D350636 017</u>		Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>14-3936</u>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				20M, 21st, 22nd holes.		Scrap + Destroy			
Doc/Data				Drillers old center.		No Repair			
Equip/Tooling				RC. Operator did not					
Handling/Pre				was didn't install					
Material				Drill sig correct / No	Q52042	\$72.07			Q52042
Operator	14/06/06	110	X1	Reventerph done on drill	14/04/06				14/06/06
Offset/Setup				Sig setup					
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

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Item ID: D350-636-017

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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A/R Aluminum Rod batch: _____

9-Grind welds flush as per Dwg D4168

120 QC10- Inspect visual per QSI004- ground welds 0.00

120

QC Memo 0.00

Quality Control

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00

Quality Control

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

closed & to
SCRAPPED.
14-6-9.

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N900040100Setup Start ***NS1***

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160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes using hole saw of Detail C and ground handling to 0.625"
(total of 8 holes per side)
as per dwg D4168.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)
as per dwg D4168.

3- Open float hole using uni-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291 batch: _____
exp. date: _____

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: _____

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

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Stop *NS2*

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12- C'bore section CJ-CJ. ADJUST TOOLING AS REQUIRED.
VERF BY: _____

13- Deburr holes, ensure tube is free of all scratches before sending to
paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****
*****REF TO W/O BATCH: _____*****

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

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Item ID: D350-636-017

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Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	QC5- Inspect part completeness to step on W/O	0.00							
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180

QC

Memo

0.00

Quality Control

190	Pressure Wash per QSI005 4.3	0.00							
-----	------------------------------	------	--	--	--	--	--	--	--

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200		0.00							
-----	--	------	--	--	--	--	--	--	--

200

SprayPaint

Memo

0.00

SprayPainting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: _____

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: _____

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Item ID: D350-636-017

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N900040100

Setup Start ***NS1***

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Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

230

HandFinishing

0.00

230

HandFinish

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D4168

2-Inspect for Foreign Objects

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as

per dwg D4168

SIKA FLEX 241

BATCH: _____

EXP DATE: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: _____

5-Coat all exposed fasteners with "LPS Procyon" batch: _____

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Item ID: D350-636-017**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible**Start Date:** 5/30/14 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 5/30/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

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Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

Stop *NR2*

270	0.00
-----	------

0.00

Packaging	Memo	0.00				
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Packaging Identify and pack for shipping as per PPPD350-636-017
Location: _____
PPP rev: _____

280	QC21- Final Inspection - Work Order Release	0.00
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QC21- Final Inspection - Work Order Release

QC	Memo	0.00
----	------	------

Quality Control

Picklist Print

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Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as
per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN
12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	115.0000	4	4			
D3490-1													
Cross Bolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				115					
				112737				1					
				116358				114					
AN3C34A		Purchased	No			230	Each	32.0000	1	1			
AN3C34A													
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				32					
				m127044				32					
AN3C36A		Purchased	No			230	Each	170.0000	4	4			
AN3C36A													
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				25					
				101261				4					
				122204				11					
				124827				10					
				ST514				145					
				m127769				5					
				m128398				65					
				m128773				75					

Picklist Print

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN3C37A	Purchased	No	230	Each	386.0000	1	1
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Start Qty: 1.00

Required Qty: 1.00

AN3C37A

BOLT:

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST353	10	
M124131	1	
M127823	9	
ST514	376	
M128491	176	
M128773	200	

AN3C42A	Purchased	No	230	Each	40.0000	1	1
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AN3C42A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
121103	5	
ST353	35	
m127300	1	
m128491	9	
m128830	25	

D3490-5	Manufactured	No	230	Each	32.0000	4	4
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D3490-5

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	32	
109104	32	

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D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3492-1 Manufactured No 230 Each 144.0000 8 8

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	144	
111578	2	
112738	8	
114879	134	

D3492-5 Manufactured No 230 Each 129.0000 8 8

D3492-5

Plug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	129	
104854	9	
105612	39	
112740	81	

D3873-1 Manufactured No 230 Each 223.0000 7 7

D3873-1

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST067	223	
104858	5	
105611	217	
109110	1	

D4154-041 Manufactured No 230 Each 4.0000 1 1

D4154-041

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	4	
106716	1	
114212	3	

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Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D4170-1

Manufactured No

230

Each

Start Qty: 1.00
101.0000 4 4

Required Qty: 1.00

D4170-1

Bushing

Location

Loc Qty

Loc Code

LG001

101

107896

101

D4171-1

Manufactured No

230

Each

15.0000 1 1

D4171-1

Bushing

Location

Loc Qty

Loc Code

ST098

15

109144

15

MS21043-3

Purchased No

230

Each

528.0000 5 5

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

55

124555

35

m126741

20

ST509

393

m128398

393

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Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0363R Purchased No 230 Each 1,265.000 9 9

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Washer

Location	Loc Qty	Loc Code
FP001	580	
114742	580	
Return2014	6	
114742	6	
ST292	679	
122441	79	
m128591	600	

NAS1515H3L Purchased No 230 Each 483.0000 4 4

***NAS1515H3L ***

Washer

Location	Loc Qty	Loc Code
FG	40	
102472	40	
ST297	443	
m127831	159	
m128976	284	

NAS1611-005 Purchased No 230 Each 171.0000 8 8

NAS1611-005

O-RING

Location	Loc Qty	Loc Code
FP001	171	
m126974	96	
m129198	75	

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Start Date: 5/30/14

Required Date: 5/30/14

NAS1611-010

Purchased

No

230

Each

Start Qty: 1.00
195.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

Location

Loc Qty

Loc Code

FP001

195

m126988

3

m127813

4

m128375

80

m128388

8

m129198

100

NAS1149D0863J

Purchased

No

250

Each

859.0000 2 2

NAS1149D0863.J

Washer

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

57

125484

57

ST510a

800

125268

600

125635

200

D2744

Manufactured

No

110

Each

21.0000 1 1

D2744

Cap

BE14-0604

Location

Loc Qty

Loc Code

LG001

21

Y15440

21

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2600-3-BENT

Manufactured No

110 Each

8.0000 Start Qty: 1.00 1 1

Required Qty: 1.00

D2600-3-BENT

Extrusion Bent

Location

Loc Qty

Loc Code

LG
117904
LG002
112976

7
7
1
1

160 Each

124.0000 8 8

① 14-6-2 JK/BB

D2743

Manufactured No

D2743

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG
111570
112729
LG001
109799

123
8
115
1
1

160 Each

12.0000 1 1

D2739

Manufactured No

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG
111094
113252
117803
LG002
115881

5
1
1
3
7
7

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 765.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Rivnut

Location	Loc Qty	Loc Code
FG	30	
M127028	30	
FP001	461	
M128649	461	
ST280	248	
M127028	10	
M128179	238	
st555	26	
M127092	26	

AN8C35A Purchased No 230 Each 55.0000 1 1

AN8C35A

Bolt

Location	Loc Qty	Loc Code
FG	4	
121275	4	
FP001	51	
m126293	29	
m127823	22	

D3488-041 Manufactured No 230 Each 9.0000 1 1

D3488-041

Blade Fitting LH

Location	Loc Qty	Loc Code
FP001	9	
111463	8	
88255	1	

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN6C44A

Purchased

No

230

Each

Start Qty: 1.00
127.0000 4 4

Required Qty: 1.00

AN6C44A******

Bolt

LocationLoc QtyLoc Code

FG

2

103964

2

ST341

28

m128319

28

ST505

97

m128700

47

m129199

50

MS21083C8

Purchased

No

230

Each

161.0000 1 1

MS21083C8******

Nut

LocationLoc QtyLoc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

D3631-1

Manufactured

No

230

Each

180.0000 8 8

D3631-1******

Washer

LocationLoc QtyLoc Code

FP001

180

110258

16

111019

12

115800

52

119553

100

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00
5,700.000 4 4

Required Qty: 1.00

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

GA	825	
125654	825	
Return2014	41	
122063	41	
ST292	1676	
124580	8	
125654	8	
m128591	1660	
st510	3158	
m126319	61	
m127306	2500	
m127410	563	
m127831	34	

D2745

Manufactured

No

230

Each

78.0000 8 8

D2745

Bushing

Location

Loc Qty

Loc Code

ST017	78	
107336	4	
111554	8	
113176	58	
90323	2	
93336	6	

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0832R

Purchased

No

230

Each

Start Qty: 1.00
290.0000 1 1

Required Qty: 1.00

NAS1149C0832R******

Washer

LocationLoc QtyLoc Code

ST292

290

122441

23

m114915

117

m125807

150

AN3C6A

Purchased

No

230

Each

1,265.0000 4 4

AN3C6A******

Bolt

LocationLoc QtyLoc Code

FG

10

122416

10

ST351

2

m128224

2

ST513

1253

m125709

257

m128769

996

MS21043-6

Purchased

No

230

Each

218.0000 4 4

MS21043-6******

NUT

LocationLoc QtyLoc Code

FG

20

103693

20

ST315

10

m127255

10

ST509

188

m127813

188

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3493-1

Manufactured No

250

Each

Start Qty: 1.00
199.0000 2 2

Required Qty: 1.00

D3493-1

Washer

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

189

109105

159

112741

30

MS21083C8

Purchased No

250

Each

161.0000 2 2

MS21083C8

Nut

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

AN8C21A

Purchased No

250

Each

49.0000 2 2

AN8C21A

Bolt

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

3

m128319

2

m128849

1

ST508

42

m127823

42

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Work Order ID: 119938

119938

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2741

Manufactured No

250

Each

34.0000

Start Qty: 1.00

1 1

Required Qty: 1.00

D2741

Blade

Location

Loc Qty

Loc Code

FG

14

100664

5

115522

5

98323

4

FP001

1

88824

1

ST466

19

107206

2

113640

12

115522

5

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.3) PER DART QSI 005 4.3
BLACK ANTI-ISKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER

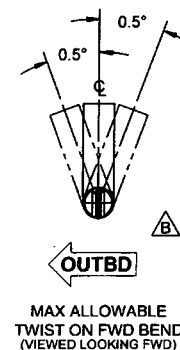
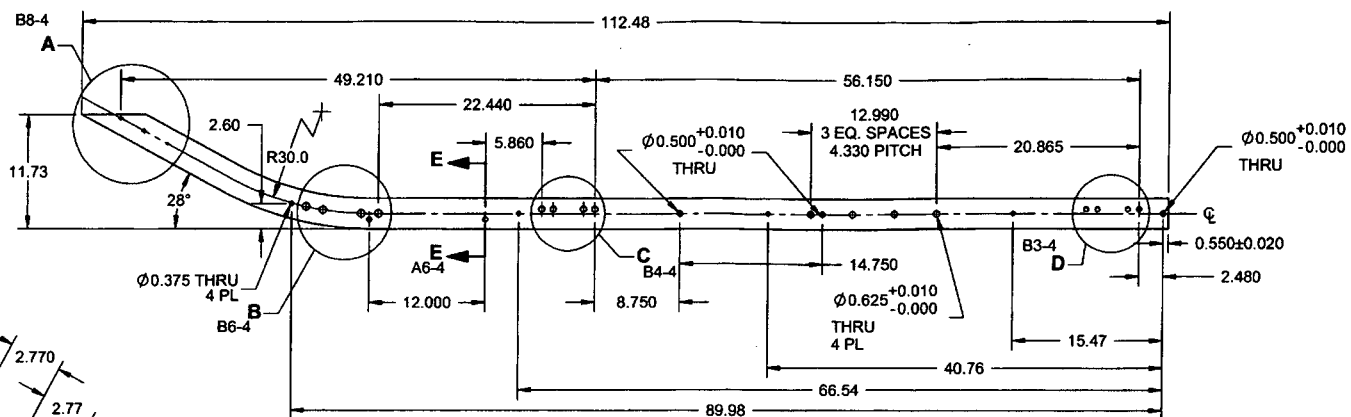
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1405-36

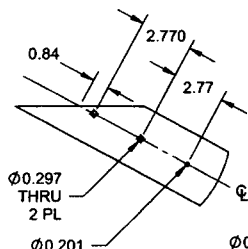
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2013-08-13
JMP

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (2N D-1-4/-5/-6/-7), UPDATED FINISH OPTIONS. REASON: PAR13-278 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	13.07.11		

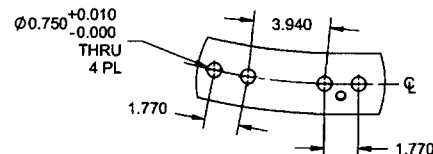
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TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
SCALE NTS	
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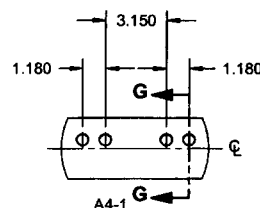
D4168-1 LH SKIDTUBE



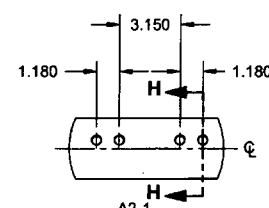
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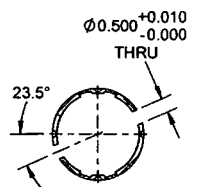
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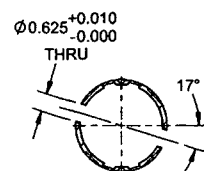
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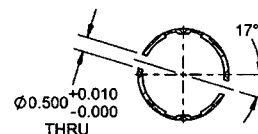
DETAIL D
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SECTION E-E
SCALE 3X, 2 PL



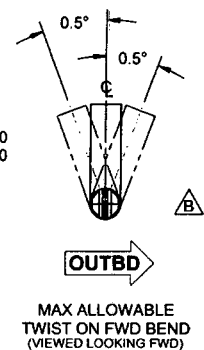
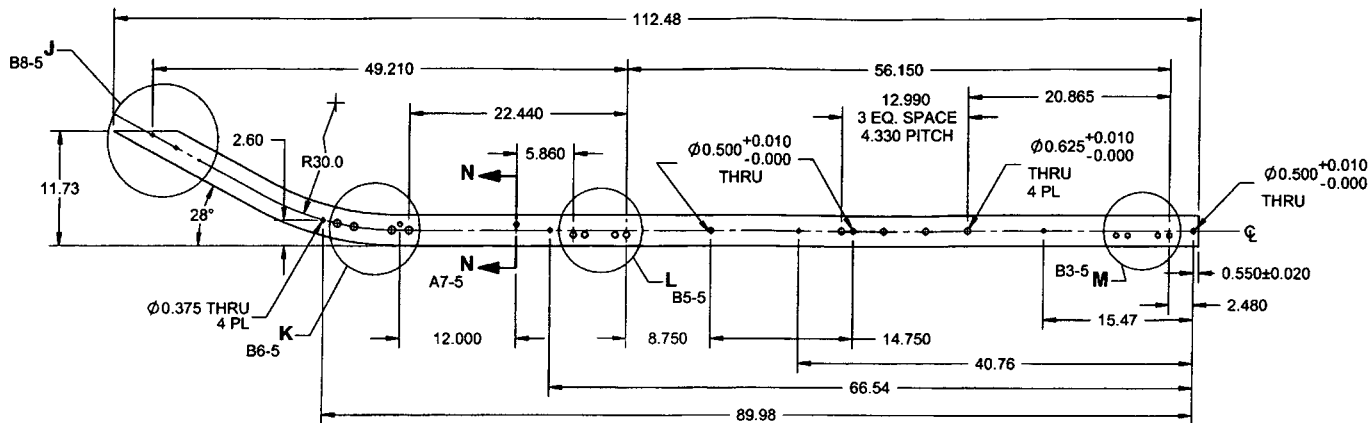
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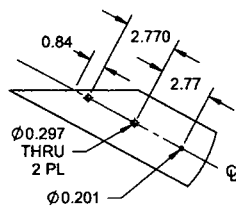
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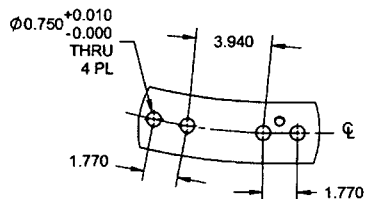
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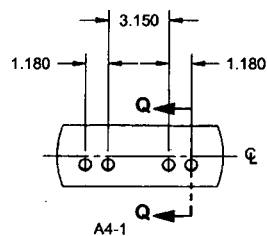
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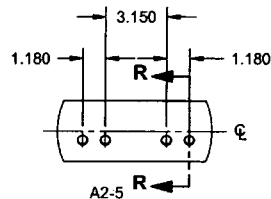
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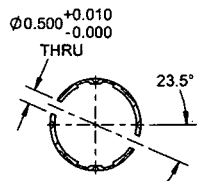
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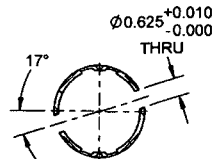
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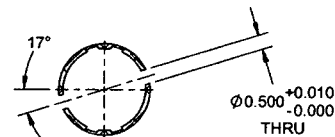
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SECTION N-N
SCALE 3X, 2 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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APPROVED
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DATE 13.07.11

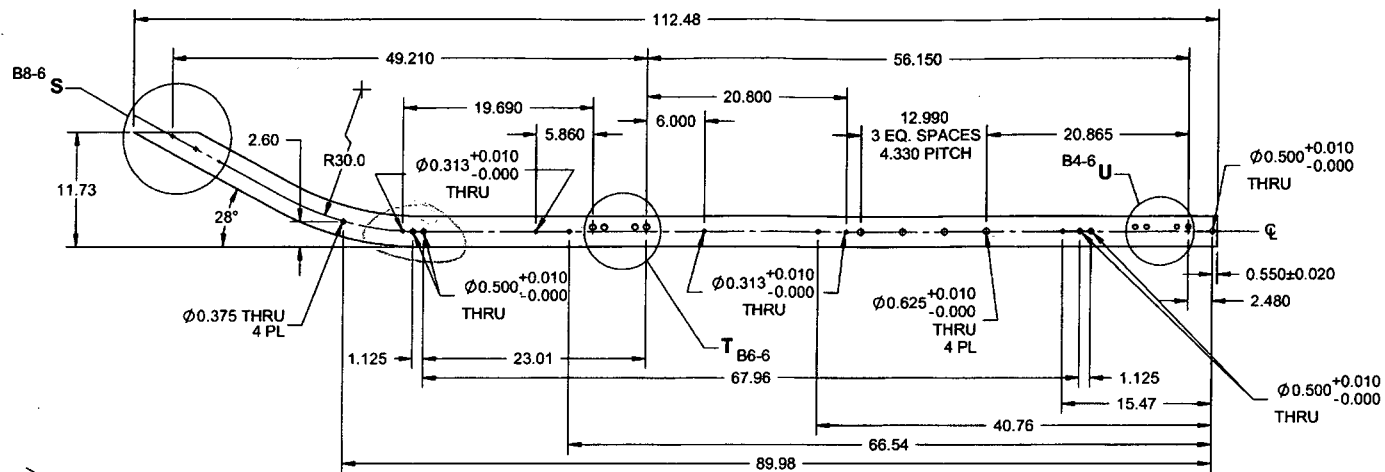
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4168
TITLE
350 SKIDTUBE ASSEMBLY

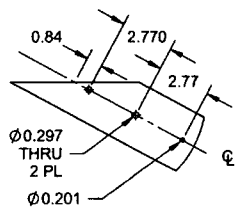
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SCALE
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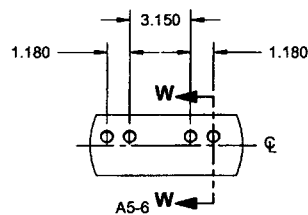
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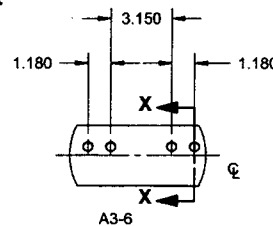
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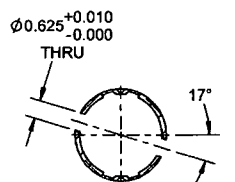
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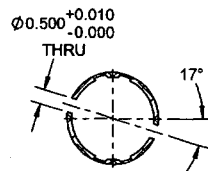
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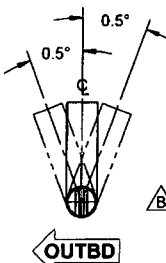
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SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

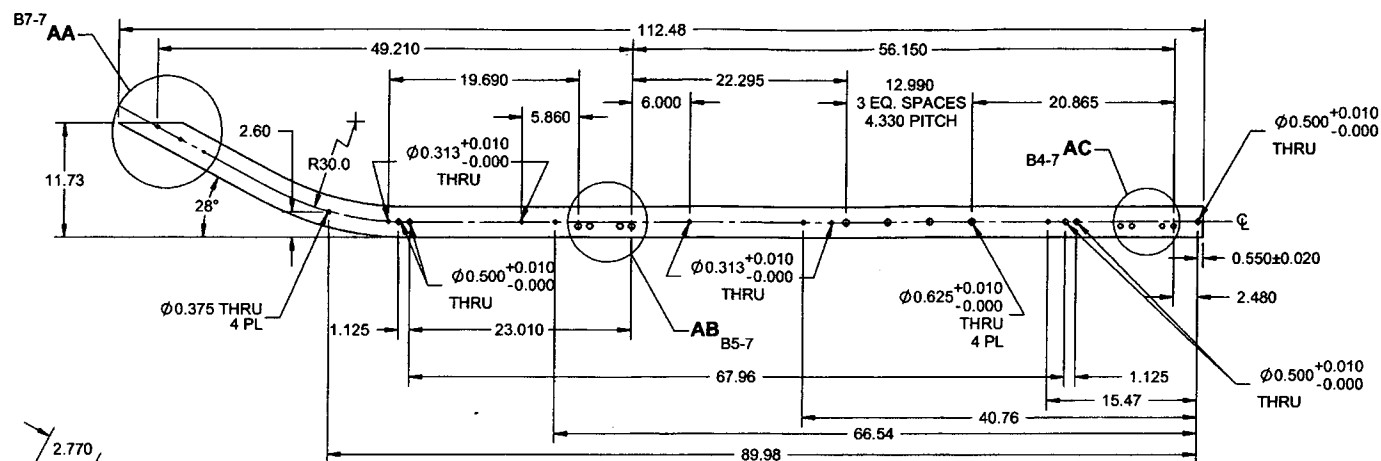


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

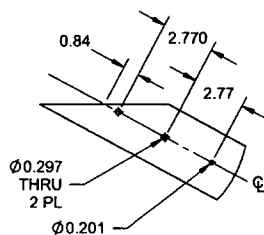
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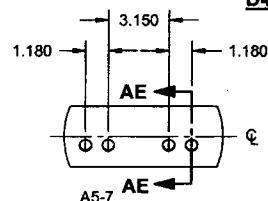
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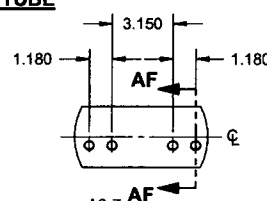
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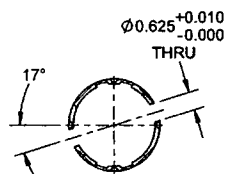
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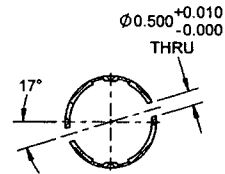
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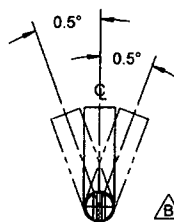
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SCALE 2X



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL



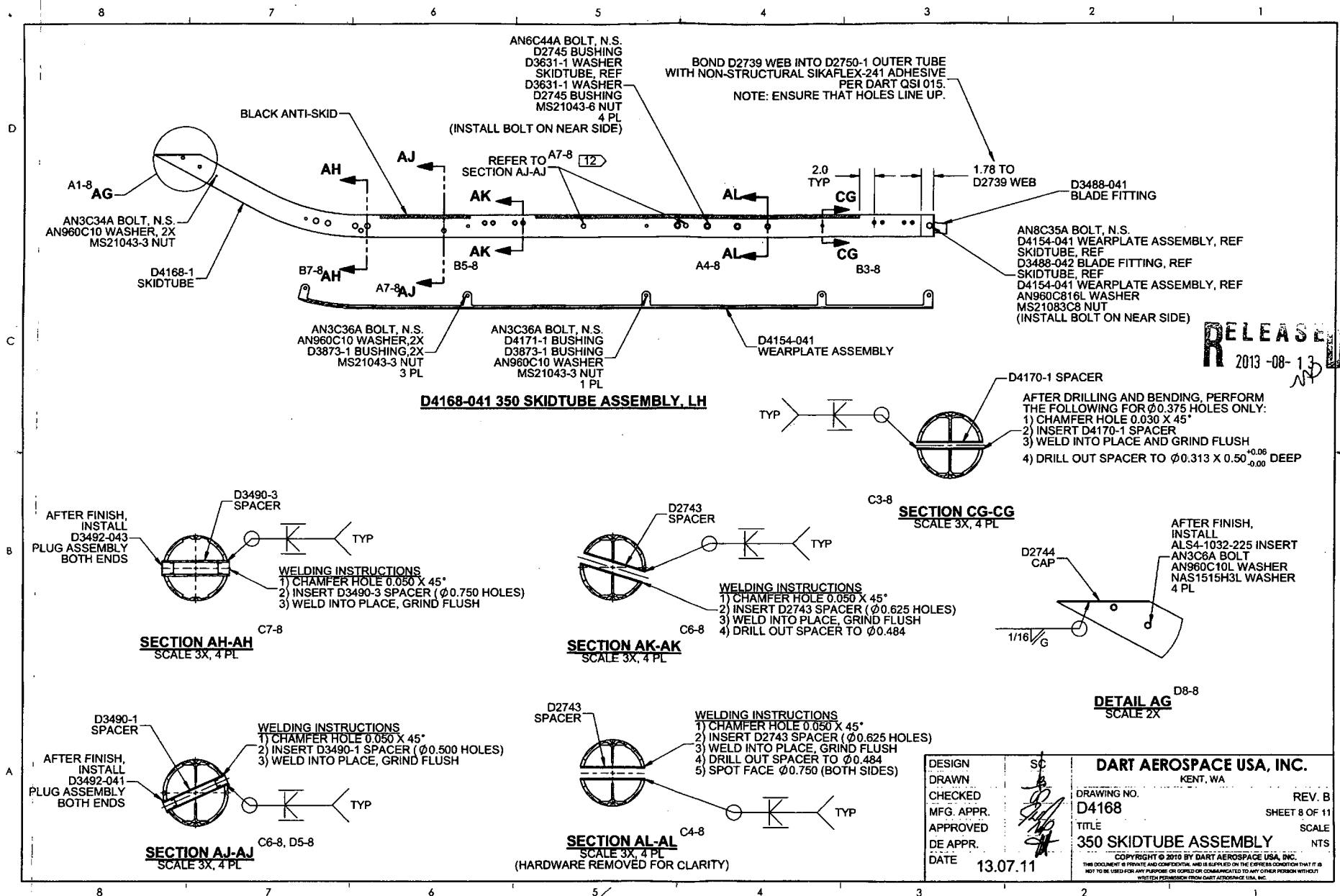
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

RELEASED
2013-08-13

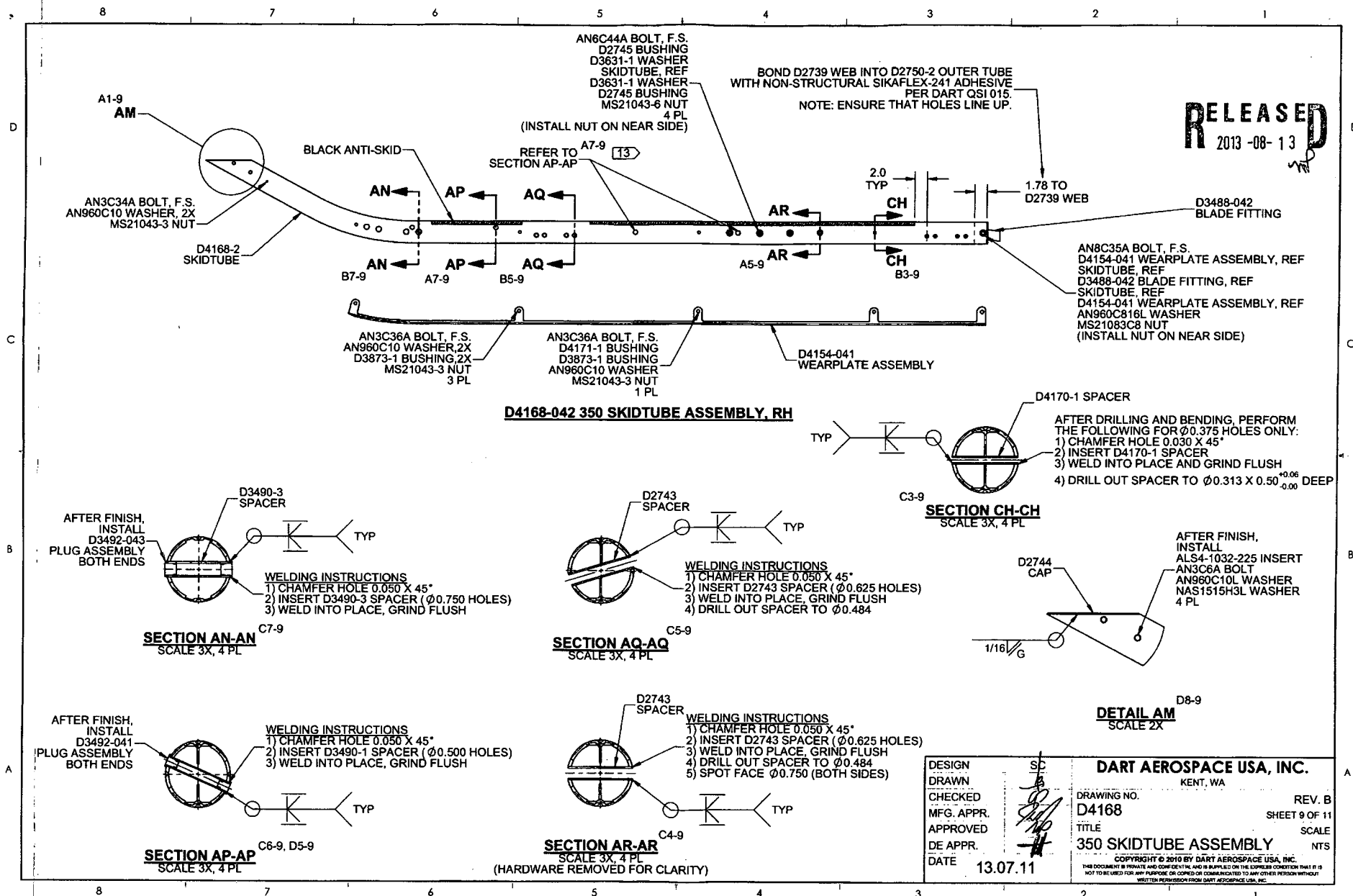
DESIGN DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE	SC [Signature] [Signature] [Signature] [Signature] 13.07.11	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4168 TITLE 350 SKIDTUBE ASSEMBLY <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
		REV. B SHEET 7 OF 11 SCALE NTS	

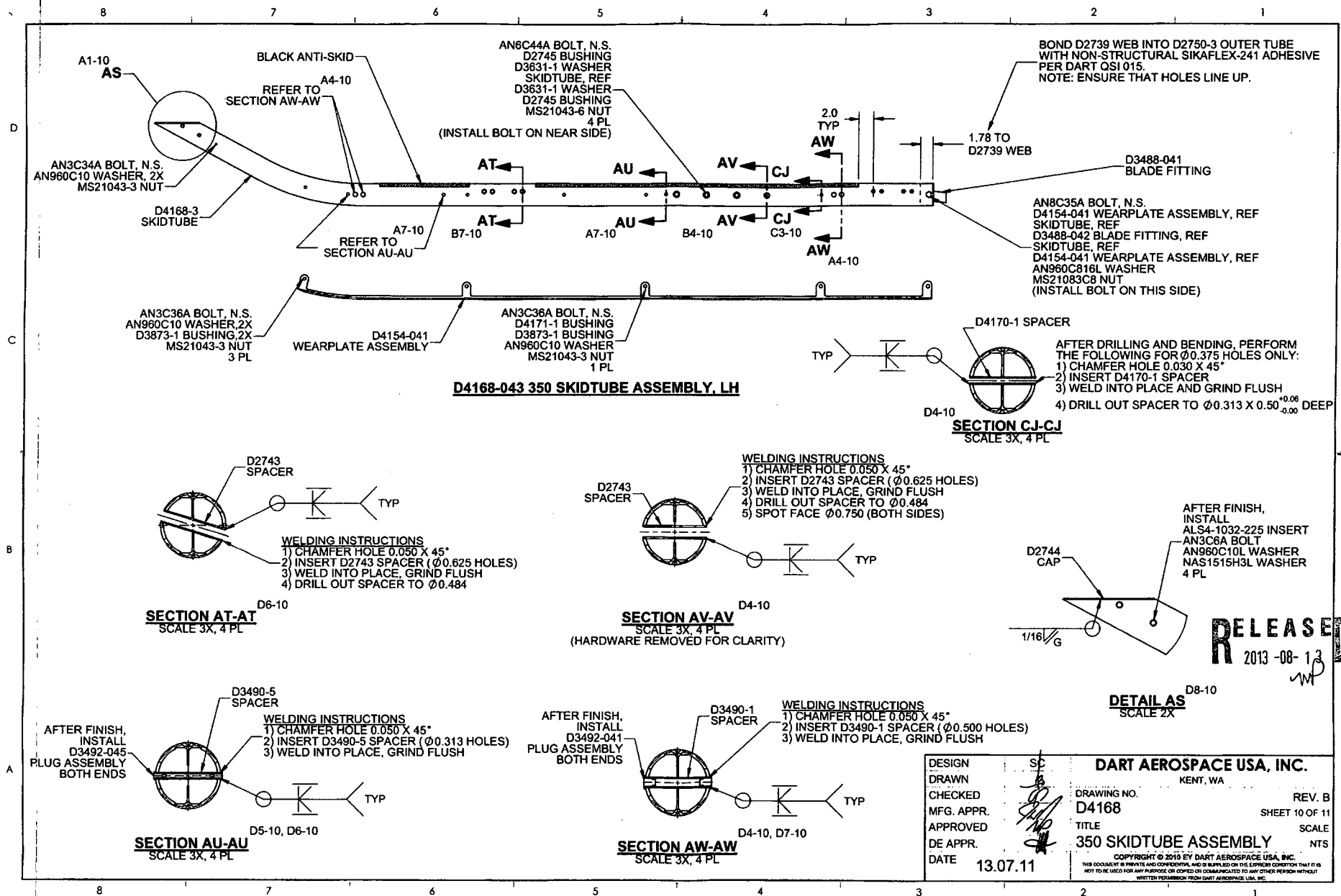
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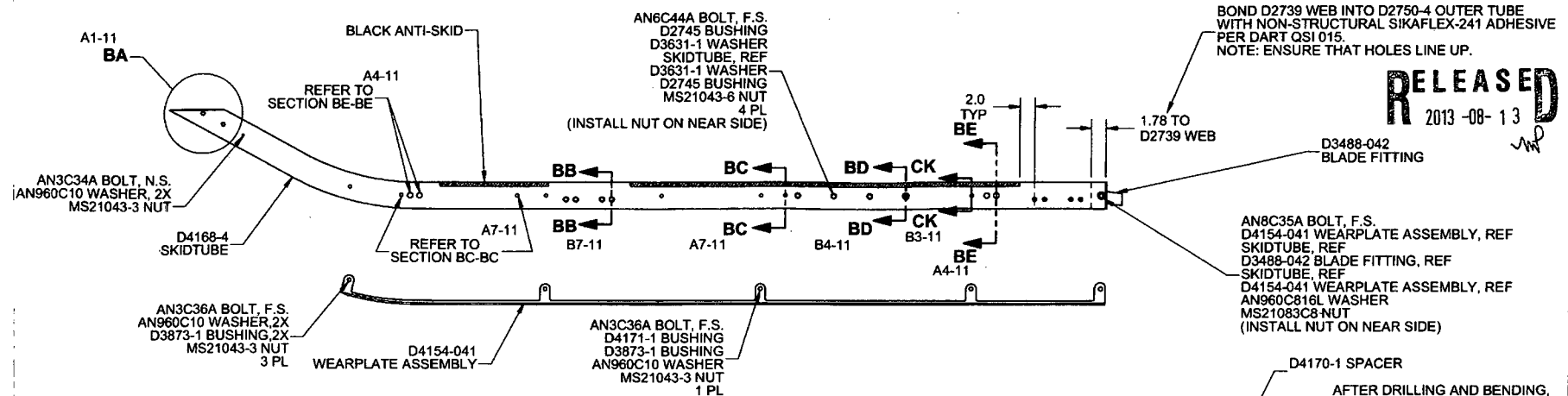
RELEASED
2013-08-13

RELEASED
2013-08-13

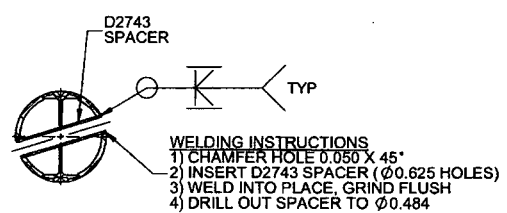




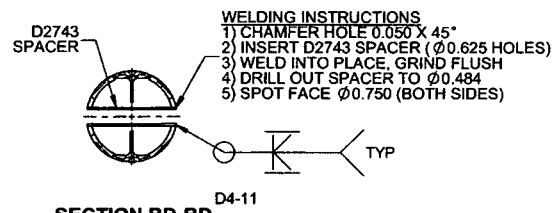
RELEASED
2013-08-13



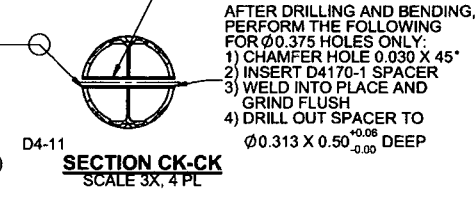
D4168-444 350 SKIDTUBE ASSEMBLY, RH



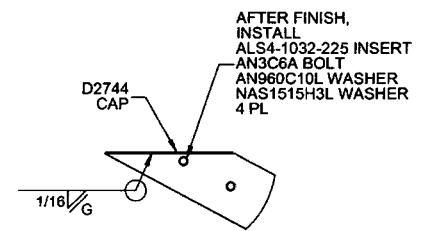
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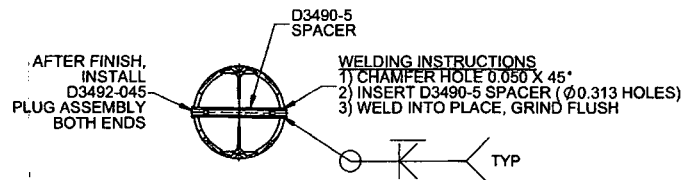
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



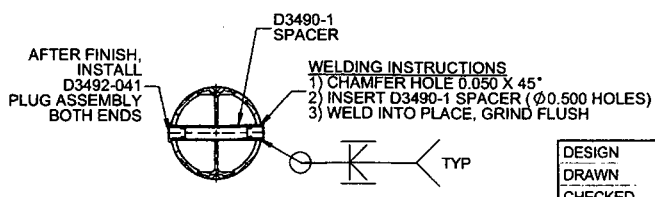
SECTION CK-CK
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	13	KENT, WA	
CHECKED	13	DRAWING NO:	REV. B
MFG. APPR.	13	D4168	SHEET 11 OF 11
APPROVED	13	TITLE	SCALE
DE APPR.	13	350 SKIDTUBE ASSEMBLY	NTS
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Cash x-5.14

#5.0 12.00